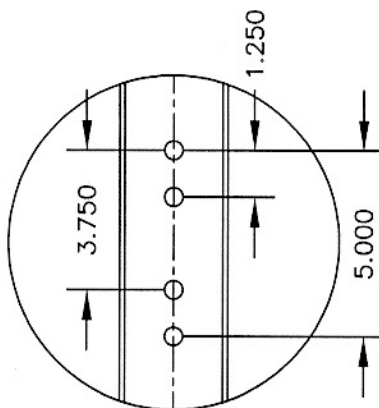
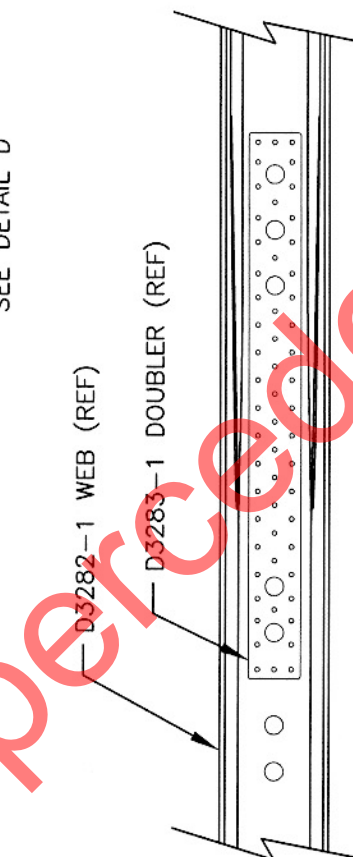
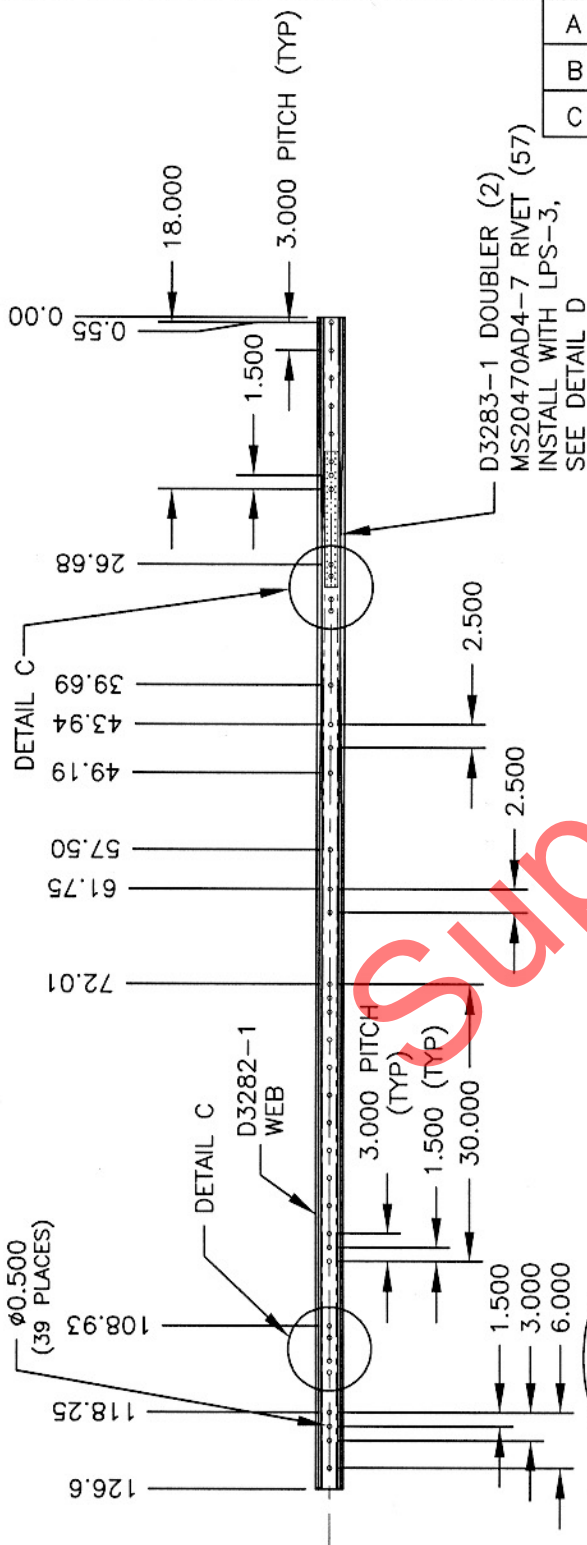


DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>H</i>	APPROVED	<i>H</i>	DRAWING NO. D3282
				REV. C SHEET 1 OF 2
DATE	05.08.09	TITLE	FLOAT WEB, 206L/407	SCALE 1:20
A	04.05.05	NEW ISSUE		
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS		
C	05.08.09	REMOVE D3390-1, NOW MACHINED		



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY

RELEASED05.09.12 *H***D3282-041 FLOAT WEB**

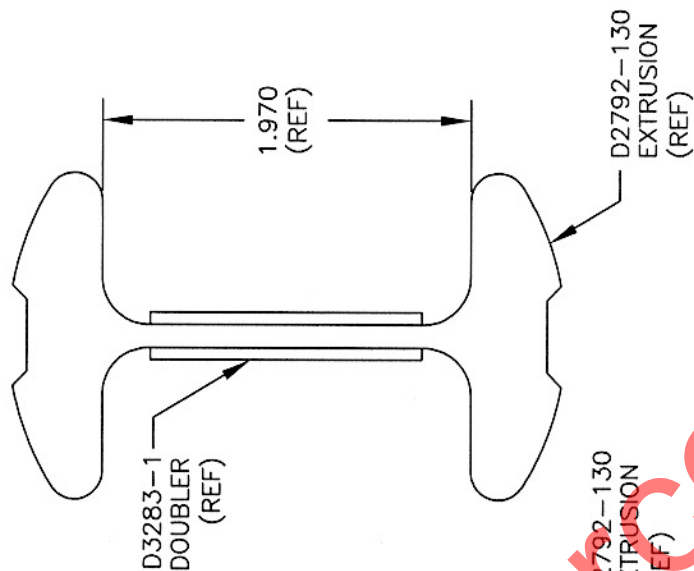
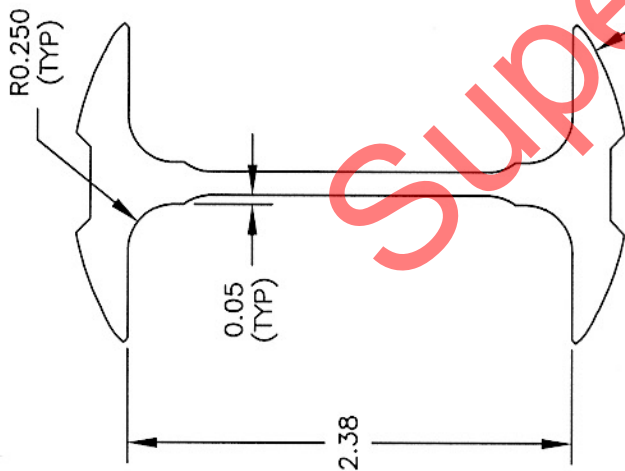
- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3282	REV. C SHEET 2 OF 2
DATE 05.08.09	TITLE FLOAT WEB, 206L/407		SCALE 1:20

SECTION B-B**SECTION A-A****D3282-1 MACHINING NOTES**

1 UNIFORM SECTION A-A

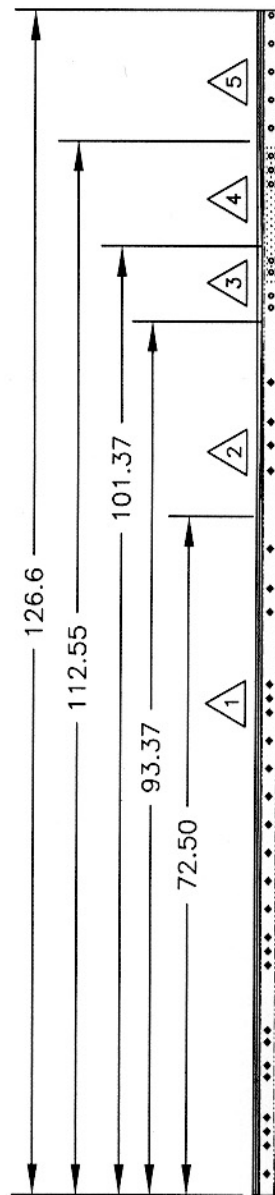
2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B

3 UNIFORM SECTION B-B

4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE

5 UNIFORM SECTION A-A

6 R1.00 BETWEEN SECTIONS

**RELEASED**

05-09-12

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